

Work Order ID 53210

October 26, 2009 2:17:36 PM

PRELIMINARY ISSUE

Page 1

Item ID: D4011-1

Revision ID: A-PRELIM 04.10.26

Item Name: Clamp, Short

Start Date: 10/26/09 Start Qty: 8.00

Required Date: 10/28/09 Req'd Qty: 8.00

Reference:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Setup Start

Stop

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4011	A-PRELIM

100		0.00
-----	--	------



Purchasing

Purchasing

Memo

Issue P/O:

Manufacture as per Dwg D4011

Supplier: G.F.I.

Material release note is required

0.00

→ QC2 - B 9-10-07

B 9-10-07

105 small fab

Bent per drawing

110



Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

→ 8-10-07

0.00

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

Make only 8

Work Order ID 53210

October 26, 2009 2:17:37 PM



Page 2

Item ID: D4011-1

Accept



Setup Start



Revision ID: A-PRELIM

Stop



Item Name: Clamp, Short

Start Date: 10/26/09 Start Qty: 8.00



Cust Item ID:

Required Date: 10/28/09 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00	USE FOR TESTING.						
			SCRAP REMAINING PARTS						
Packaging	Memo	0.00	A 0611.27.						
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

NA

Signature Prototype only
09.10.30

P20324A DEC

Wg 12.16

POSITIVE RECALL
EFFECTIVE _____ AUTH _____
RELEASED _____ DATE _____
0611.27

Picklist Print

October 26, 2009 2:17:35 PM

Work Order ID: 53210



Parent Item: D4011-1

Parent Item Name: Clamp, Short



Start Date: 10/26/09

Required Date: 10/28/09

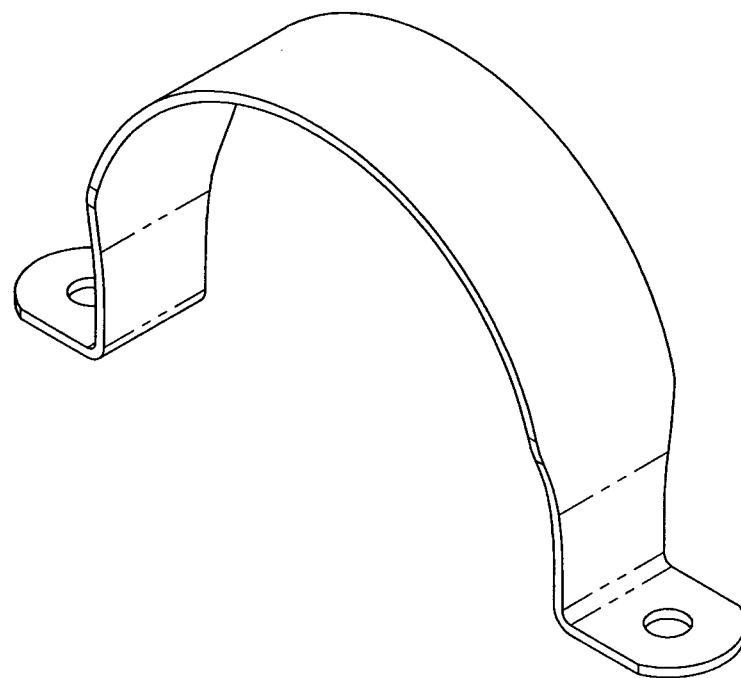
Comments:

Start Qty: 8.00

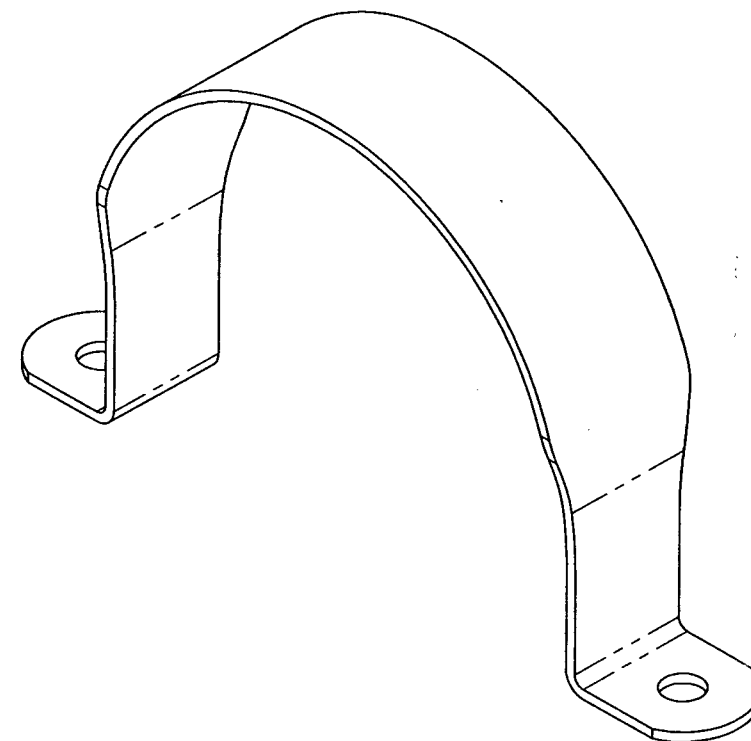
Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	219.8531	0.4884	7500		
304/316 Sheet .063											18 9-10-07	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	219.8530737	
106860	16.018	
111924	25.1689737	
112442	43.1663	
112567	7.4998	112567
112885	128	



D4011-1 CLAMP, SHORT



D4011-3 CLAMP, LONG

PRELIMINARY ISSUE

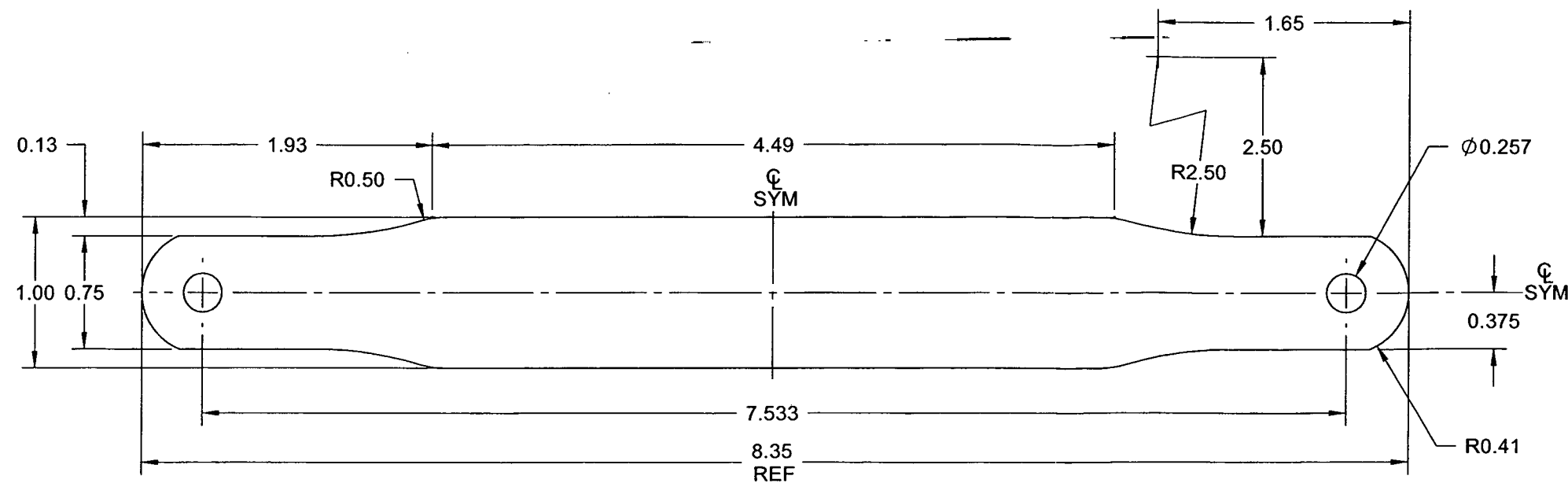
04.10.26
Per ECN #09-695P

NOTES:

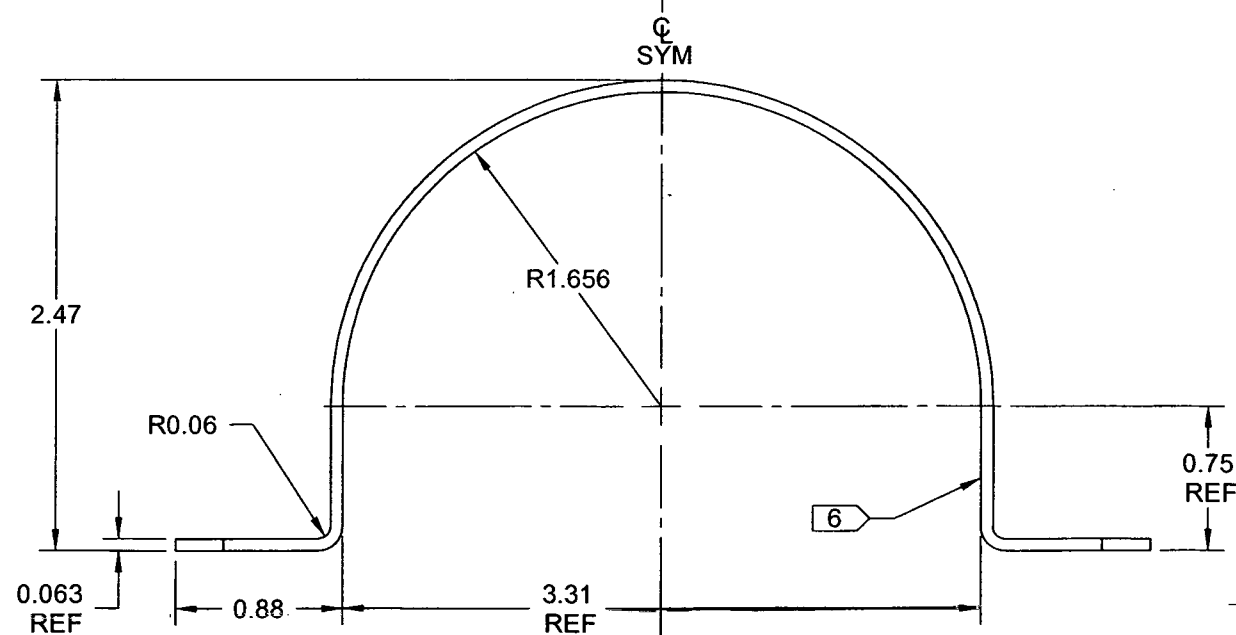
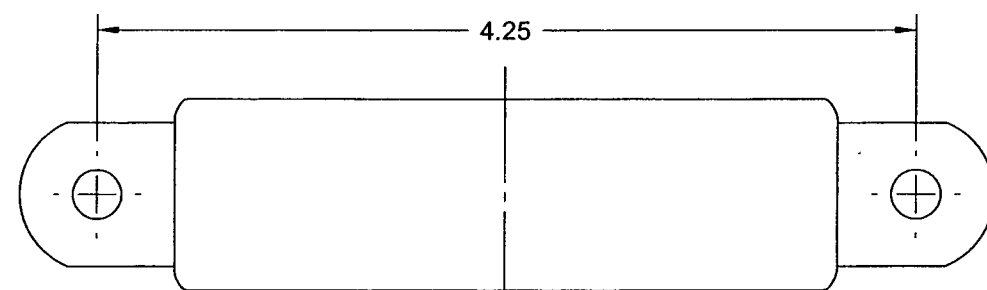
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4011-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs EACH

A	NEW ISSUE	MB	09.10.21
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4011	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CLAMP	NTS
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8 7 6 5 4 3 2 1



D4011-1F CLAMP, SHORT FLAT PATTERN



D4011-1 CLAMP, SHORT
(MAKE FROM D4011-1F)

PRELIMINARY ISSUE

09.10.26
Pte DCN # ~~09-695P~~
#09-695P

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4011	SHEET 2 OF 3
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8 7 6 5 4 3 2 1

Receiving Report

Date: 9/9/02

Batch No: M112067

Supplier: MAGNA

Dart P/O: 10312

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☒ N/A ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection ☒ 8 N/A ☐
 Work Order 09109/02 N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M6061	TGB-200x0400 24	40	0	0	40	
M6061	30181x0400 40	40	0	0	40	
M6061	TGB1-200x0400 40	40	0	0	40	

M6061 TGB-200x0400

Initials of receiver (if shipment OK) Level 12

Production/Admin:

Date

Received/Costing

Initial

09/09/02

RCR 10312

CR

Location

M 3045126A

64 0 0 69



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO10312

Purchase Order Date 9/01/09

PO Print Date 9/01/09

Page Number 4 of 4

Order From :

VC-MAG002

MAGNA STAINLESS
5775 RUE KIERAN
ST LAURENT, QC H4S 0A3
CA

Contact Name

Vendor Phone

800 363 6646

Vendor Fax

514 339 1105

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

16	✓ M304S16GA	304/316 Sheet .063	9/04/09 Yes	✓ 96 92.00 sf	Yours ppd	\$5.0000	\$460.00
----	-------------	--------------------	----------------	---------------------	-----------	----------	----------

Special Inst: AS ABOVE

17	✓ M304S20GA	304/316 .040 Sheet	9/04/09 Yes	✓ 192.00 sf		\$3.9062	\$749.99
----	-------------	--------------------	----------------	----------------	--	----------	----------

Special Inst: AS ABOVE

PO Total: \$5,356.49

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 9/01/09

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

MILL TEST REPORT

TA CHEN INTERNATIONAL CORPORATION

www.tachen.com

This MTR contains 1 page (Page: 1)

MTR#: TICL2121 Customer#: MAGDOR PO#: P006327 SO#: PE6925
 Item#: 16GA48963042B Bundle#: KA80261180E10H5 Heat#: A2800233



INSPECTION CERTIFICATE

TICL2121

Shanxi Taigang Stainless Steel CO.,LTD Member
 of Taiyuan Iron and Steel (Group) Co.,LTD

NO.2 jiancaoping, Taiyuan, Shanxi, P.R.China

TEL: (0351)3013328 FAX: (0351)3017816

http://www.tisco.com.cn

E-mail: tgbxg@tisco.com.cn

MILL TEST CERTIFICATE

CERTIFICATE NO. T08-692B
 MATERIAL A181304 NO.2B FINISH
 SPECIFICATION ASTM A240-04/A480-04, ASME SA240/A480
 ASTM A866, AMS 5513/5511
 L/C No.

CUSTOMER

CONTRACT NO.

DATE OF ISSUE

Ta Chen International, Inc.

1.22628

20080401

Product

Melting furnace

Inspectors stamp

Mark of the Manufacturer

SHEET

E+VOD

Shanxi Taiyuan Stainless Steel Co.,Ltd

NO.	Heat No.	Coil No.	Batch No.	Quantity	Dimensions (inch)	Weight(Pound)
43	C3706216	KA71272980F00H3	78253308	1	16GA x 48" x 120	4535
44	C3706216	KA71272980F00H2	78253309	1	16GA x 48" x 120	4546
45	A2800233	KA80261180E10H5	78255632	1	16GA x 48" x 96	4270
46	A2800233	KA80261180E20H1	78255634	1	16GA x 48" x 96	4259
47	A2800233	KA80261180E20H2	78255636	1	16GA x 48" x 96	3874
48	A2800233	KA80261180E20H3	78255638	1	16GA x 48" x 96	4348
49	A2800233	KA80261180E20H4	78255640	1	16GA x 48" x 96	3896

Chemical Composition

Heat No.	C	Si	Mn	P	S	Cr	Ni	Cu	Al	N	Mo	Ti
C3706216	0.055	0.560	1.090	0.028	0.001	18.190	8.160	0.160		0.066	0.090	
C3706216	0.055	0.560	1.090	0.028	0.001	18.190	8.160	0.160		0.066	0.090	
A2800233	0.042	0.491	1.143	0.026	0.002	18.337	8.012	0.119		0.080	0.093	
A2800233	0.042	0.491	1.143	0.026	0.002	18.337	8.012	0.119		0.080	0.093	
A2800233	0.042	0.491	1.143	0.026	0.002	18.337	8.012	0.119		0.080	0.093	
A2800233	0.042	0.491	1.143	0.026	0.002	18.337	8.012	0.119		0.080	0.093	
A2800233	0.042	0.491	1.143	0.026	0.002	18.337	8.012	0.119		0.080	0.093	
A2800233	0.042	0.491	1.143	0.026	0.002	18.337	8.012	0.119		0.080	0.093	

Mechanical Properties (Test temperature :20°C)

Test No.	Tensile R _m N/mm ²	R _{p0.2} Yield _{0.2%} N/mm ²	R _{p1.0} Yield _{1.0%} N/mm ²	Elongation		Corrosion Tests	Hardness		
				A5 (%)	A50(%)		HRB	HV	HRC
78253308-T	660	305			54		91.5-90.5		
78253309-T	660	305			54		91.5-90.5		
78255632-T	645	299			51		87.5-88.0		
78255634-T	645	299			51		87.5-88.0		
78255636-T	645	299			51		87.5-88.0		
78255638-T	645	299			51		87.5-88.0		
78255640-T	645	299			51		87.5-88.0		

SPECTROMETER SORTING TEST: OK

EN 10204-3.1B

Mercury Free

Place: Taiyuan

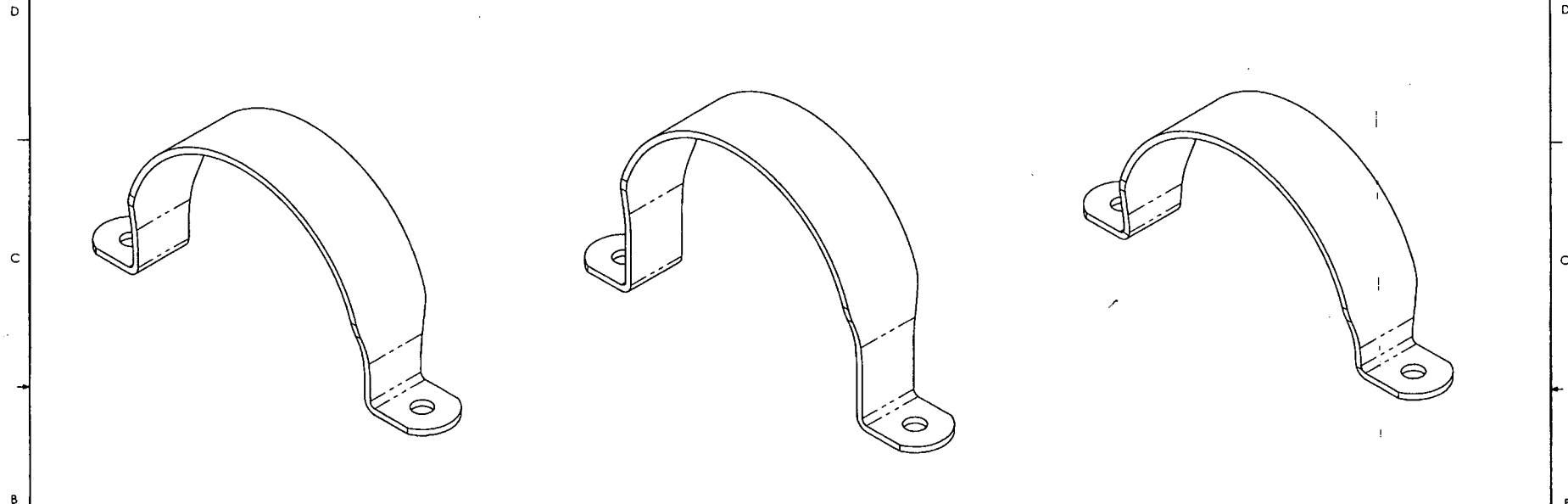
Work Inspector: 李忠新



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P006327 - A2800233

8 7 6 5 4 3 2 1



D4011-1 CLAMP, SHORT

D4011-3 CLAMP, LONG

D4011-5 CLAMP, SHORT (OEM)

53210

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2009-11-24
MP

NOTES:

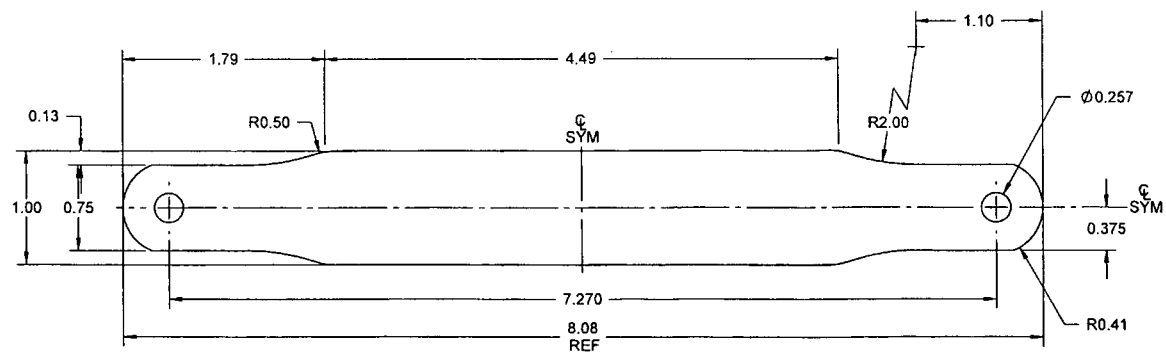
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4011-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs EACH

B	SHORTEN HEIGHT OF -1/3 CLAMPS BY 0.125; ADDED -.5. REASON: PROVIDE MORE CLEARANCE UPON INSTALLATION ON OEM SKIDTUBES		MB	09.11.11
A	NEW ISSUE		MB	09.10.21
REV.	DESCRIPTION		BY	DATE
DESIGN	DART AEROSPACE LTD			
DRAWN	HAWKESBURY, ONTARIO, CANADA			
CHECKED	ASS	DRAWING NO.	REV. B	
MFG. APPR.	DS	D4011	SHEET 1 OF 4	
APPROVED	MP	TITLE	SCALE	
DE APPR.	MP	CLAMP	NTS	
DATE	09.11.11		<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. WHO IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CORNER OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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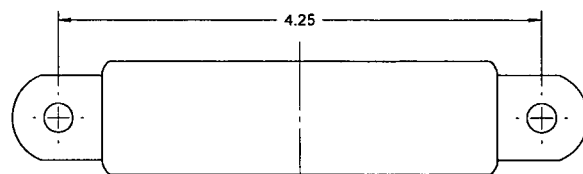
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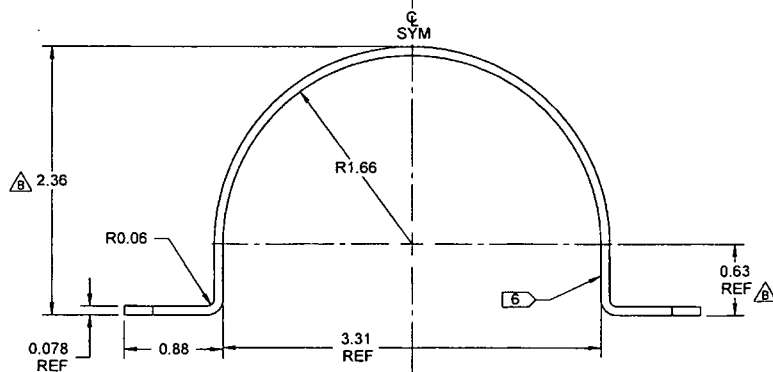


D4011-1F CLAMP, SHORT FLAT PATTERN

C



B



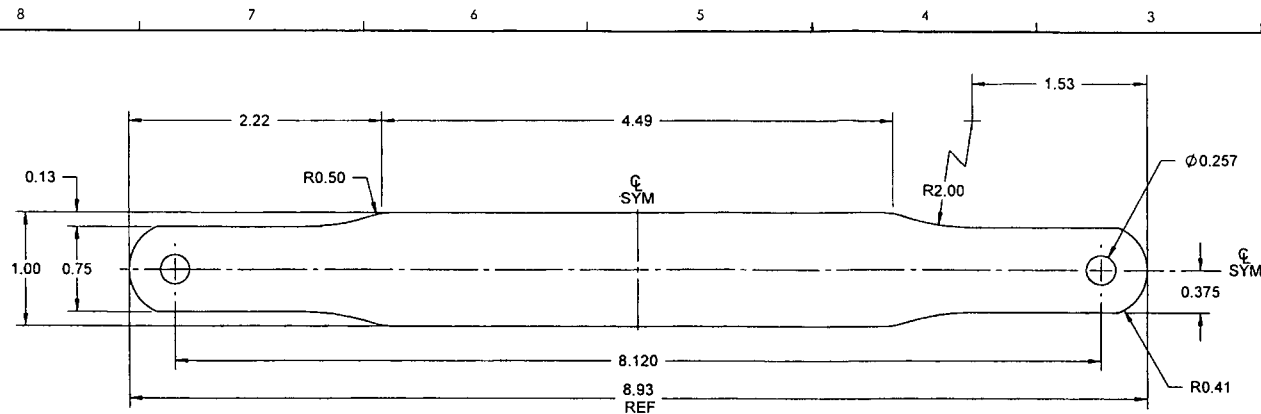
**D4011-1 CLAMP, SHORT
(MAKE FROM D4011-1F)**

53210

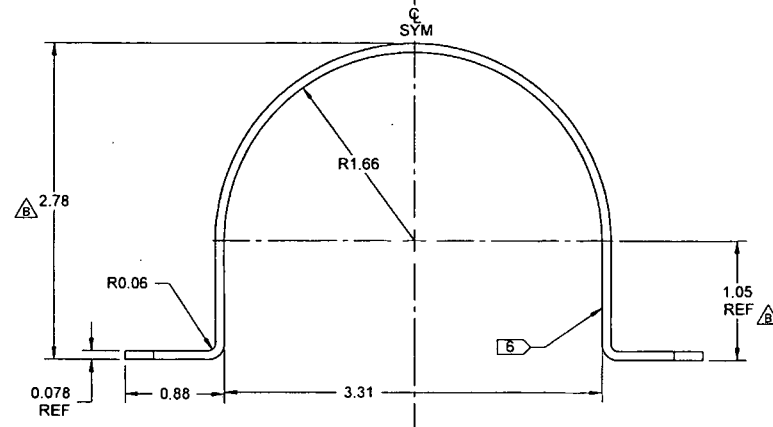
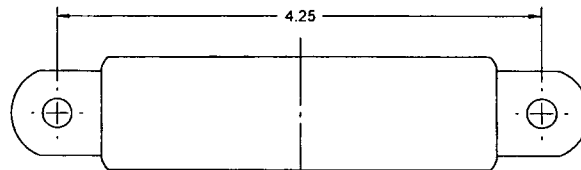
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2009-11-24
M/D

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CHECKED	ALS	DRAWING NO.	REV. E
MFG. APPR.	MS	D4011	SHEET 2 OF 4
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D4011-3F CLAMP FLAT PATTERN, LONG

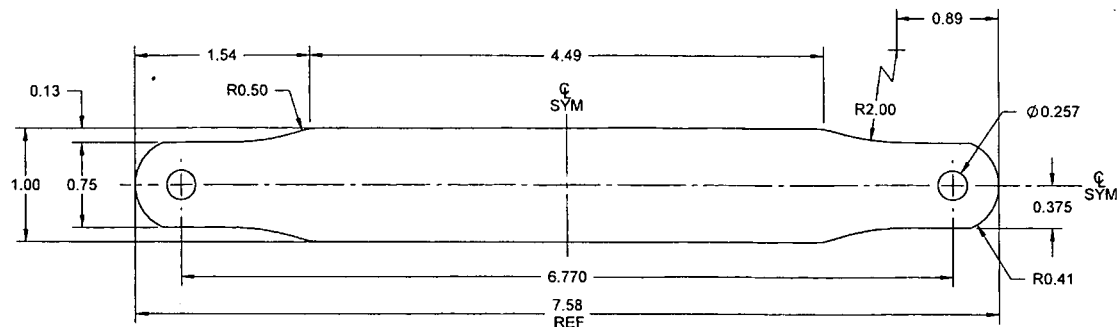


D4011-3 CLAMP, LONG
(MAKE FROM D4011-3F)

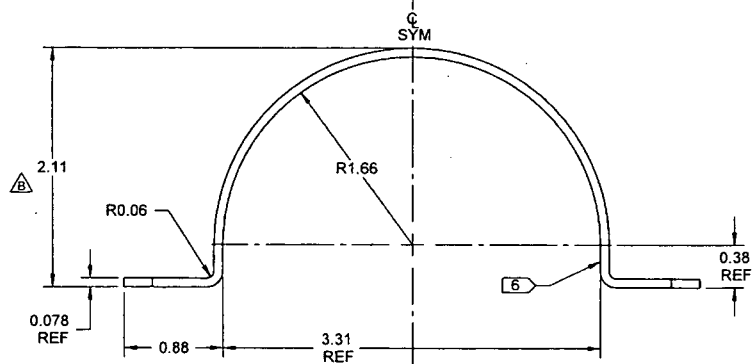
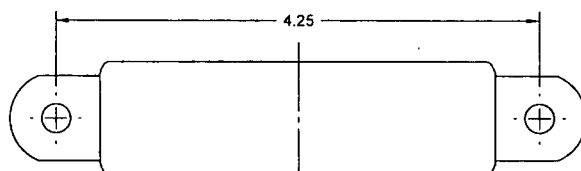
53210

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2009-11-24
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DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ALS</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4011	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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D4011-5F CLAMP, SHORT (OEM) FLAT PATTERN



D4011-5 CLAMP, SHORT (OEM)
(MAKE FROM D4011-5F)

DESIGN	1	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	1			
CHECKED	1.5		DRAWING NO.	REV.
MFG. APPR.	1		D4011	SHEET 4 OF
APPROVED	1		TITLE	SCALE
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2009-11-24

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